S259244

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

NO 20.02.28

D5799-7

Job Sheet 207426

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RECEIVED _____ BY _____

Part No: D5799-7
Part Name: Lever
Part Weight: 0 lbs
Job Created: 2/26/20
Due Date: 3/6/20
Type: Stock

Job Qty: 8 pcs
Status: New
Job Tracking No:
Created By: Jennifer Renwick
Description:

Placed by mistake NO 20.02.28

Priority: Medium

Note: URF 2020-525 DWG 5799 REV.A IPP REV:A NEW ISSUE 20.01.15 JV VERF:DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier Workcenter / Supplier Lead Time	Sign-off
100	**Waterjet - Flow - 1**	8 pcs		3/6/20	0.17	0.33	Waterjet - Flow	dc 20/02/28
110	**QC 2**	8 pcs		3/6/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	dc 20/02/28
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

PRIORITY

				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
120	**QC 8**	8 pcs	3/6/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
130	**Packaging 3-1 - Stock - B4B**	8 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B

DAS
FEB 2 8 2020
9:39

Plex 2/26/20 9:58 AM Dart/lajeunesse.marie

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 **QC 21 - SA**	8 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op Descriptions: **100** - 1-Cut as per D5799-7 DWG. DWG. Rev: A PROG. Rev: A 2-Deburr if necessary FEB 2 8 2020
110 - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	6.0096 sf (.7512 ea)	100-Waterjet - Flow - 1	S2428620

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	6	144	0

Part Specifications

Specifications could not be found.

Plex 2/26/20 9:58 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	207426
Description: Lever		Part Number:	D5799-7
Inspection Dwg: D5799-7	Rev: A		Page 1 of 1

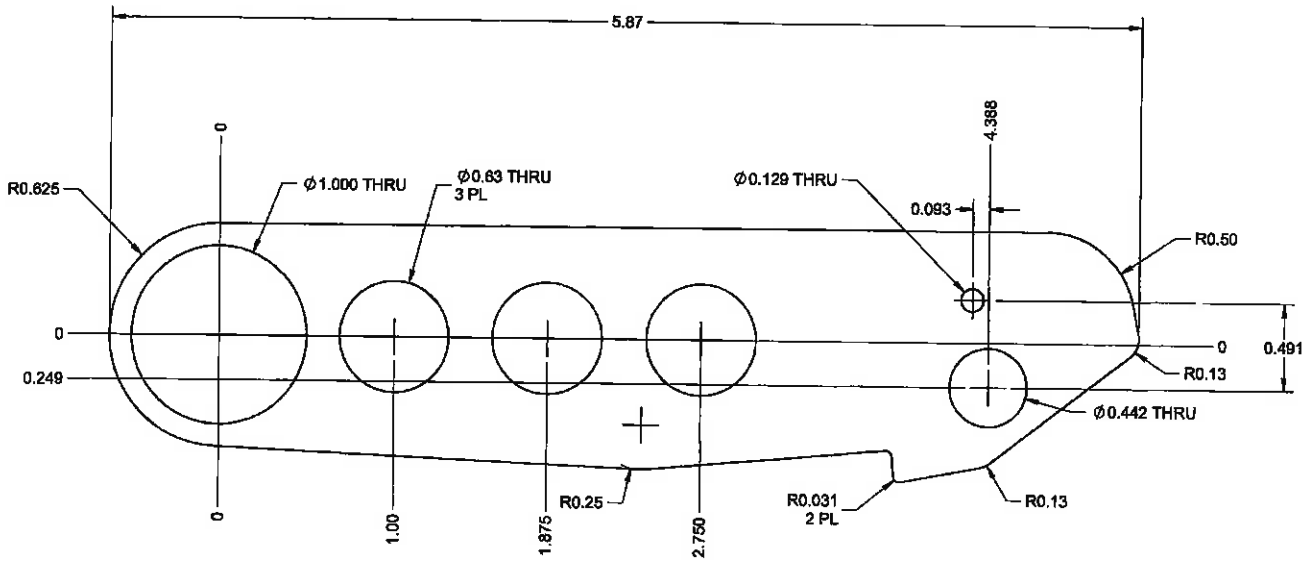
INSPECTION SHEET

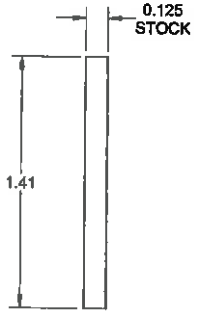
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
∅ 1.000	-.001 +.012	∅ 1.001	✓		V:D=.01	
∅ .63	-.001 +.008	∅ .629	✓			
∅ .129	-.001 +.005	∅ .132	✓			
∅ .442	-.001 +.006	∅ .443	✓			
1.00	+/- .030	1.001	✓			
1.875	+/- .010	1.874	✓			
2.750	+/- .010	2.749	✓			
1.41	+/- .030	1.409	✓			

Measured by:	DL	Checked by:	DAS 8-89	QC Inspector:	
Date:	20/02/28	Date:	FEB 2 8 2020	Date:	

Engineering Approval: (If necessary)		Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	





D5799-7 LEVER
(DERIVED FROM AERO DESIGN P/N 84265-01)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 207926 MLS
2020-02-26

UNDER REVIEW

URF 2020-525 20.02.20 (NO)

NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED, #11 GA (0.125 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: NONE
7) WEIGHT: 0.19 lbs
8) ALL NON-DIMENSIONED FEATURES TO BE WITHIN 0.030 OF "D5799-7-REVA.DXF"

RELEASED
2020 FEB 19

APPROVED

DESIGN	ZF	DART AEROSPACE LTD
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	DRAWING NO. D5799 REV. A
MFG. APPR.	DD	SHEET 3 OF 4
APPROVED	NO	TITLE HANDLE SCALE NTS
DE APPR.	CP	
DATE	20.01.10	

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB045332

Memo

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3		M6061T6S.080			6061-T6 .080 Sheet : MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 receive sf	Firmed		12/13/19	192 sf	0 sf	192 sf	$6.2664583/sf	$1,203.16
4		M304S11GA			304/316 0.125 Sheet : MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240	Firmed	-	12/13/19	96 sf	0 sf	96 sf	$13.329062/sf	$1,279.59
5		M304S14GA			304SS sheet .080 : MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 receive sf	Firmed	-	12/13/19	64 sf	0 sf	64 sf	$8.366652830/sf	$535.47

DAS 82 9-89 DEC 19 2019

ACIER OUELLETTE INC.
935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4240 Mtl: 514-336-4240 Ext.: 800-667-4240
Fax: 450-377-5698 Mtl: 514-336-4246 Ext.: 866-453-4242

DELIVERY - **MILL TEST**

Copy

COO0183417

Billed to
DART AEROSPACE LTD

1370 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Instruction : F-M

Shipped to

1370 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Att :

Delivery Route 5

Customer N°	CLIC001056
Date	2019/12/05
Delivery date	**2019/12/13**
Your order N°	PON0045332
Processed by	Josianne Bourdon
Salesman	JOSIANNE BOURDON
Carrier	OUELLETTE VALLEYFIELD
Credit Terms	Net 30 Days

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 ALU SHEET .040 (18G) 2024-T3 48 (4 X 12) DART TEALD-0404122048 12473 AC32236-SA-11/12 lot 3398886 coat: 131	81.07	144.00 1.00	PIZ_SCLB UN_SUN								
2 ALU SHEET 3/16 6061-T6 (4 X 12) FEAL-3164125061 4269 AC32233-TH-11/12 lot 1613501 H:01/0019718	128.88	48.00 1.00	PIZ_SCLB UN_SUN								
3 ALU SHEET .063 (12G) 6061-T6 (4 X 12) FEAL-0614125061 3195 TRANSHERT ST-JEROME LE 11-12 PACKAGING Lot: 400871 H: H3600231	164.39	144.00 0.00 1.00	PIZ_SCLB UN_SUN UN								
4 SHEET SS 11G SS304-2B (4 X 8) FESS-11G4830428 3402 PACKAGING Heat: C84X	594.00	96.00 1.00	PIZ_SCLB UN								
5 SHEET SS 14G SS304-2B (4 X 8) FESS-14G4830428 3412 PACKAGING Heat: LZ35HC10	209.00	64.00 1.00	PIZ_SCLB UN								
6 SHEET SS 16G SS304-2B (4 X 8) FESS-16G4830428 3419 PACKAGING Heat: 4167	336.00	128.00 1.00	PIZ_SCLB UN								
7 SHEET SS 18G SS304-2B (4 X 8) FESS-18G4830428 3426 PACKAGING Heat: C44B	672.00	320.00 1.00	PIZ_SCLB UN								

DEC 2 0 2019

LINE 4

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M3045 1164
DATE: DEC 2 0 2019

PO / BATCH NO: PO#3045332
S 242760

MATERIAL CERT REC'D: YES
QUANTITY RECEIVED: 96 SF
QUANTITY INSPECTED: 96 SF
QUANTITY REJECTED:

THICKNESS ORDERED: .125
THICKNESS RECEIVED: .125
SHEET SIZE ORDERED: 4' x 8'
SHEET SIZE RECEIVED: 4' x 8'

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	(N)	
CORRECT FINISH	(Y)	N	
CORROSION	Y	(N)	
CORRECT GRAIN DIRECTION	(Y)	N	
CORRECT MATERIAL PER M-DRAWING	(Y)	N	ASTM A240
CORRECT THICKNESS	(Y)	N	
PHOTO REQUIRED	Y	(N)	
CORRECT REF # TO LINK CERT	(Y)	N	KIT COPY
CORRECT MATERIAL IDENTFICATION	(Y)	N	
CORRECT M# ON THE MATERIAL	(Y)	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	(N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	(N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

Testers located in the Quality Office

QC INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: 32	SIGNED OFF BY:
DATE: DEC 2 0 2019	DATE:

Attach this inspection sheet with the corresponding material cert and mrrit to be scanned and received in

LINE 4

~~M5~~ M304S11GA

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: AISI 304/316 SS SHEET ANNEALED

SPECIFICATION: MIL-S-4260 OR AMS 5513 (304) OR AMS 5321 (316) OR ASTM A240 OR ASME SA240

DAS 82 8-83

DEC 2 0 2016

FINISH

FINISH	DART MANUFACTURER IDENTIFIER
UNPOLISHED No. 1	1D
UNPOLISHED No. 2D	2D
UNPOLISHED No. 2B	NONE
POLISHED No. 3	3P
POLISHED No. 4	4P
BUFFED No. 6	6P
BUFFED No. 7	7P
BUFFED No. 8	8P

PART NUMBER: M304S[TT]GA-[FI]

WHERE [TT] = GAUGE THICKNESS
WHERE [FI] = FINISH IDENTIFIER

EG 16 GAUGE SS SHEET 2B FINISH = M304S16GA
EG 16 GAUGE SS SHEET No. 4 POLISHED = M304S16GA4P

GAUGE THICKNESS REFERENCE:

GAUGE	NOM. THICK. (IN)	THICKNESS GAUGE (IN)
26	0.018750	0.019 - 0.018
25	0.021875	0.022 - 0.021
24	0.025	0.024 - 0.026
23	0.028125	0.027 - 0.029
22	0.03125	0.030 - 0.032
21	0.034375	0.033 - 0.035
20	0.0375	0.036 - 0.038
19	0.04375	0.041 - 0.046
18	0.050	0.047 - 0.052
17	0.056250	0.053 - 0.058
16	0.0625	0.059 - 0.065
15	0.070312	0.066 - 0.072
14	0.078125	0.073 - 0.083
13	0.09375	0.084 - 0.099
12	0.109375	0.100 - 0.116
11	0.125	0.117 - 0.132
10	0.140625	0.133 - 0.148
9	0.15625	0.149 - 0.163
8	0.171875	0.164 - 0.179
7	0.1875	0.180 - 0.194
6	0.2031	0.195 - 0.212
5	0.2188	0.213 - 0.228
4	0.2344	0.229 - 0.244
3	0.2500	0.245 - 0.260
2	0.2656	0.261 - 0.276
1	0.2813	0.277 - 0.293
0	0.3125	0.294 - 0.325

RELEASED
2016 FEB 04

REV	DESCRIPTION	BY	DATE
D	[illegible]	AS	[illegible]
C	[illegible]	MB	[illegible]
B	[illegible]	DP	[illegible]
A	NEW ISSUE	DS	01.02.06

DESIGN	DS	DART AEROSPACE LTD
DRAWN	AS	HAMILTON, ONTARIO, CANADA
CHECKED		REV D
MFG APPR		M304S
APPROVED		SHEET 1 OF 1
QC APPR		304/316 SS SHEET
DATE	15.01.06	SCALE NTS

(J) 3402 FESS-11G48304ZB S11304L 29638 70546 54988

North American Stainless Canada Inc.
740 Imperial Road North
Guelph, ON N1K1Z3
Canada

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 526418 1

Customer: 007050 001

Date: 7/25/2019 Page: 1

Steel: 304/304L

Finish: 2B

Your Order: 70546 NAS Order: [illegible] 0111468 02

Corrosion: ASTM A262/15a;180Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, C.R. ANNEALED & PICKLED. UNS 30430/30403
ASTM A240/18,A480/10a,A666/15,ASME SA240/17,SA480/17,SA666/17
CMTR ONLY OF FOLLOWING ASTM: A276/17,A479/17,A484/16,A312/16
CMTR ONLY ON FOLLOWING ASTM: SA312/13,SA479/13
AMS 5511R/5513J XREF; MIL-S-5059D AMD3(X CMTR ONLY); MIL-A-8625B
NACE MR0175/ISO 15156-3:2009 A, MR01.03/07;C387668-A X RAY FREE
HEAT SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; RoHS 1 & 2 compliant
Material is Free of Radioactive Contamination
Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg.by a Quality Mgt.Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DFARs Compliant

DEC 2 0 2019

82

Product Id	Coil #	Skid #	Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
05C84X AA	05C84X A		.1200	48.0000	6,442	SKIDS	144.00	19	

CHEMICAL ANALYSIS

CN(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan)

ANAB, ISO/IEC 17025, Certificate# L2323
Chemical Analysis per ASTM A751/14a

HEAT		C %	CR %	CU %	NI %	MO %	N %	MN %	P %	S %
C84X	US	.0232	18.1653	.4395	1.8189	.3810	.0620	2.0790	.0320	.0033

SN %
.2745

MECHANICAL PROPERTIES

Product Id#	Loc	Dir	UTS MPA	20C .2% YS MPA	20C ELONG % -2"	Hard HB	Tail Hard
05C84X AA	F	T	93.43	44.50	48.77	85.00	85.50

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical Dept. Mgr. KRIS TARK

Heat: C84X

2096079

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

DART AEROSPACE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced
☐ Bending
☐ Crushing
☐ Cracks
☐ Crimp/Kink/Ripple/Wave/Twist
☐ Marks/Chatter
☐ Mislabeled
☐ Contamination
☐ Misaligned/off center
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Incomplete/Unclear Instructions
☐ Drill Holes
☐ Fit/Function
☐ Power Loss/Surge
☐ Folio/Program
☐ Grain Direction
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set/Set-up
☐ Positioned Wrong
☐ Outside Tolerance
☐ Drawing
☐ Finish
☐ Part Lost/Missing
☐ Misread

Other/Details: